

Work Order ID 70339

Friday, June 03, 2011 9:08:53 AM



Page 1

Item ID: D4021-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Hoop

Start Date: 6/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/06/03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4021	B								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D4021								
	Prog Rev: <u>3</u>								
	Dwg Rev: <u>B</u>								
	Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B11-6-66B11-6-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

Sublet

x6



QC

Memo

0.00

Quality Control

130 0.00



Small Fab

Memo

0.00

Small Fab

1- make radius as per dwg
2- deburr

ES 4/06/14 6

140 QC5- Inspect part completeness to step on W/O

0.00

Sublet

x6



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/9/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *WA*

0.00

SAD

(6)

Packaging

Memo

0.00

11-06-16

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

u lo / 16

MF 11-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 03, 2011 9:08:50 AM

Page 1

Work Order ID: 70339



Parent Item: D4021-7



Parent Item Name: Hoop



Start Date: 6/3/2011

Required Date: 6/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.625X3.000 		Purchased	No			100	f	5.0000	0.4166	2.631158			
304 BAR .625 X 3.00													
<hr/>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT050	5						
						117130	5						
										<u>117130</u>			

181-6-6

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

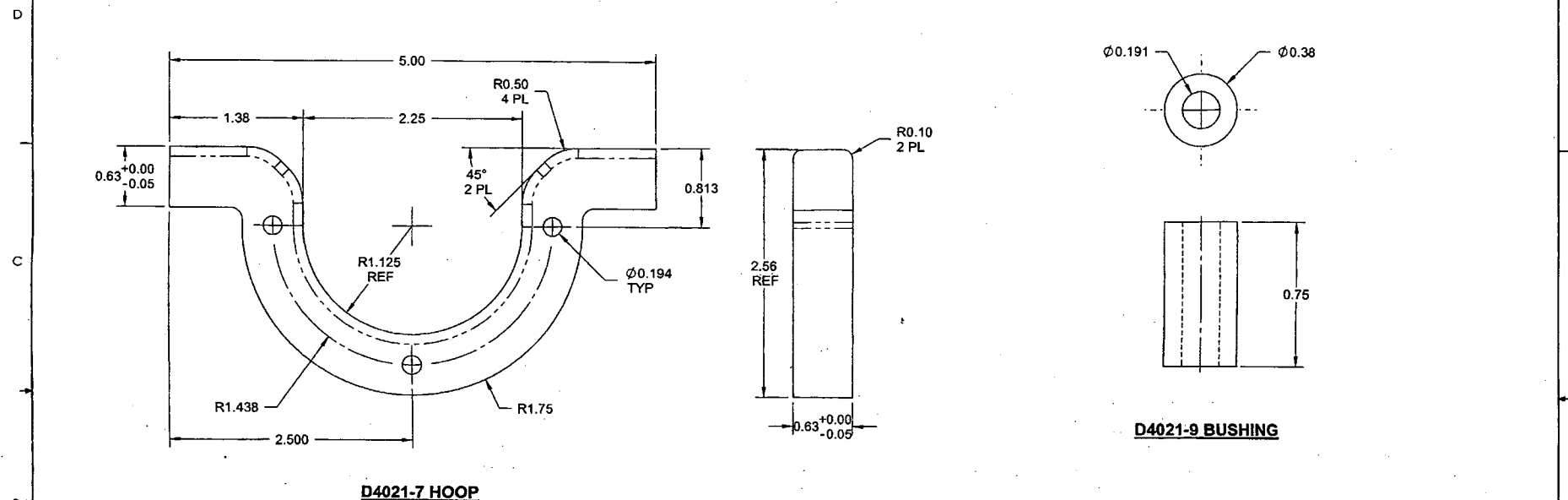
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4021-7 HOOP

D4021-9 BUSHING

CL11106103
W10: 70339

RELEASED
2010-04-14
MP

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D4021	SHEET 3 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

